

Work Order ID 66941

Thursday, March 03, 2011 8:44:14 AM



Page 1

Item ID: D3235-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 3/3/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: *11-03-3*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.820"

Batch:

Cut @ meter

CZ 11/03/04

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Echo FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr

Purchasing

Issue 7/6 to meter 7/6 13611

CZ 11/03/04

(60)

120

0.00



QC2-Inspect parts off machine FA/FAIB

Memo

0.00

Quality Control

Rec'd

*rec'd + inspect for transit damage
attached C of C to W/O*

Machine as per Dwg D3235 REVA

104/3/18 60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



Item Name: Mounting Lug

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Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 60.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Swlos 1/5

*counted
x60*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

60 BK 11-3-22

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M 115951

START TIME: *9:30*
OVEN TEMPERATURE: *320°*
FINISH TIME: *10:00*

60 BK 11-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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Stop



Item Name: Mounting Lug

Start Date: 3/3/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

60x m-1 11/03/23

180



Packaging

Packaging

Identify as per dwg & Stock Location: ST471 0.00

Memo

0.00

ES 11/03/23 60

190



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

11/3/23

11/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 8:44:23 AM

Page 1

Work Order ID: 66941

Parent Item: D3235-1

Parent Item Name: Mounting Lug





Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-1P 		Purchased	No			100	Each	0.0000	1	60			
lug D2423 		Manufactured	No			110	f	485.9514	0.0683	4.313684			
Lug Extrusion													

Handwritten notes:
 4/3/11 60
 C211/03/04

Location

Loc Qty

Loc Code

MAT06

485.9514265

43722

180

45800

17.9514265

63005

288

4.313

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

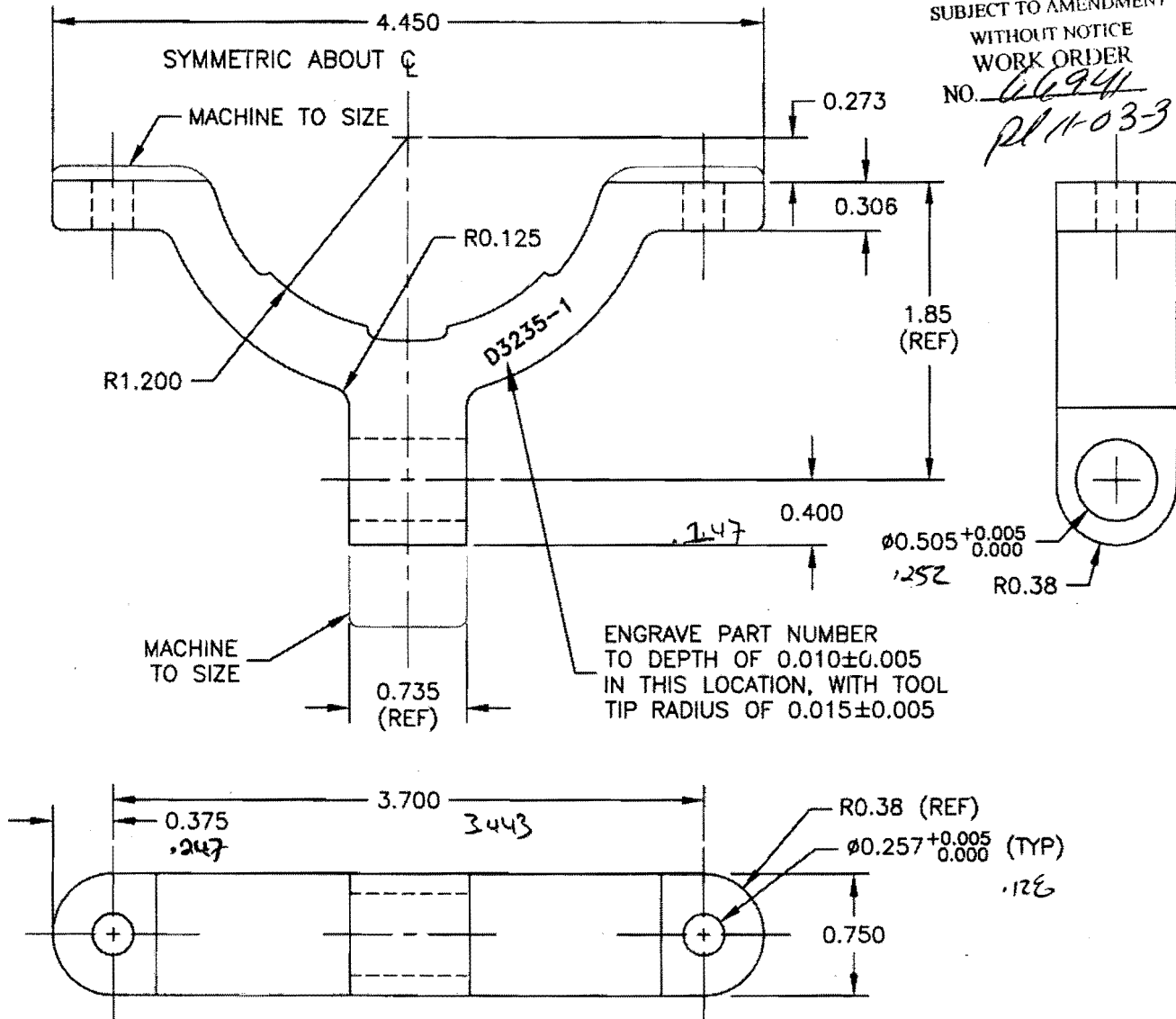
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	SHOP COPY

RELEASED
040405

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *66941*
PL 11-03-3

**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13611

Purchase Order Date 3/4/2011
PO Print Date 3/10/2011

Page Number 1 of 1

Order From : VC-MET003

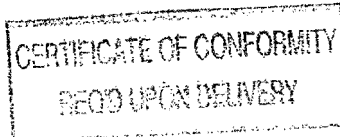
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

REVISED
\$

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-3P	LUG	3/23/2011 Yes	160.00 Each		\$13.6000	\$2,176.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B66936				
2	D3235-1P	lug	3/18/2011 Yes	60.00 Each		\$15.0500	\$903.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B66941				
PO Total:							\$3,079.00



Change Nbr: 3

Change Date: 3/10/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

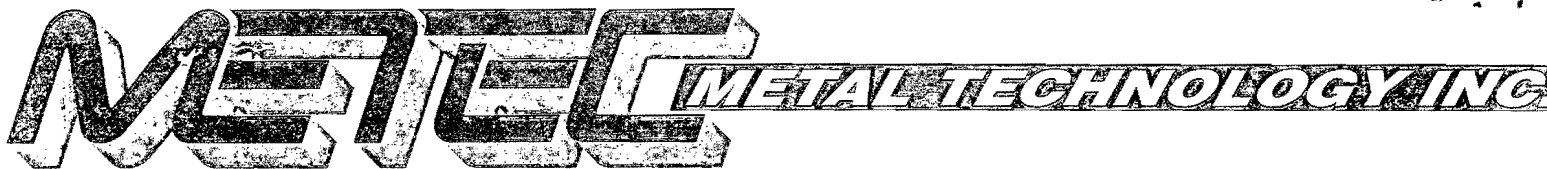


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17831
Date: Mar 17, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13611	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Material supplied by DART: D2423 B	Each	160 1		160
D3235-1 Mounting Lug Material supplied by DART: D2423 B45800 for 30 pcs. D2423 B63005 for 30 pcs.	Each	60 1	60	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
30	D3235-1P	Lug	13611
	MATERIAL: supplied by DART D2423 B63005		
30	D3235-1P	Lug	13611
	MATERIAL: supplied by DART D2423 B45800		

Sulogis

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, March 17, 2011

